

Work Order ID 143671

143671

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Item ID: D044-662-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R44 Bearpaws
 Start Date: 3/21/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 3/31/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: *glt* Date: *20160318* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D044-662	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD044-662-011	CHG004							
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

Cancel

DAS
6
9-89

MAR 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Item ID: D044-662-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R44 Bearpaws

Start Date: 3/21/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/31/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-662-011 LOCATION: FG014								
130	QC21 - Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.01							
Quality Control									

DAS
21
9-89

AUG 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 143671

143671

Parent Item: D044-662-011

D044-662-011

Parent Item Name: R44 Bearpaws

Start Date: 3/21/2016

Required Date: 3/31/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:C04.02.19 Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
IPP Rev:D As per ECN 932 & 862 06-07-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4953-1 *D4953-1* Cushion		Manufactured	No			110	Each	4.0000	4	12		9-89 DAS 6 9-89	
** 14248													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST545	4						
						131442	4						
D3075-1 *D3075-1* Bearpaw(Foot Print Only)		Manufactured	No			110	Each	1.0000	2	6		9-89 DAS 6 9-89	
**													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST	1						
						130315	1						
D2529 *D2529* Washer		Manufactured	No			110	Each	568.0000	8	24		9-89 DAS 6 9-89	
**													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST009	68						
						140554	68						
						ST012a	500						
						141458	500						
D3556-1 *D3556-1* Clamp		Manufactured	No			110	Each	7.0000	4	12		9-89 DAS 6 9-89	
**													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST542	7						
						139670	7						

(K5) 14382 MAR 22 2016

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Work Order ID: 143671

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Parent Item: D044-662-011

D044-662-011

Parent Item Name: R44 Bearpaws

Start Date: 3/21/2016

Required Date: 3/31/2016

Start Qty: 3.00

Required Qty: 3.00

D3601-1

Manufactured No

110

Each

200.0000

8

24

D3601-1

Radius Block

DAS

6

~~9-59~~LocationLoc QtyLoc Code

ST046

200

141269

200

AN4-14A

Purchased

No

110

Each

425.0000

4

24
12***AN4-14A***

Bolt

DAS

6

~~9-59~~LocationLoc QtyLoc Code

FG

5

122141

5

ST344

420

M133998

420

AN4-15A

Purchased

No

110

Each

337.0000

4

12

AN4-15A

Bolt

DAS

6

~~9-59~~LocationLoc QtyLoc Code

GA

40

120449

40

over003

200

m134370

200

ST343

97

m133769

2

m134055

95

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Work Order ID: 143671

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Parent Item: D044-662-011

D044-662-011

Parent Item Name: R44 Bearpaws

Start Date: 3/21/2016

Required Date: 3/31/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0463J

Purchased

No

110

Each

3,406.000

8

24

NAS1149D0463J

WASHER

DAS
6
9-00

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST263

2181

M134039

2181

ST269

988

M132317

100

M132677

888

24

MS21042L4

Purchased

No

110

Each

3,028.000

8

24

MS21042L4

Locknut

DAS
6
9-00

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

432

m133769

432

OVER007

1500

m134502

1500

ST303

962

m134055

962

ST305

97

m130922

97

24

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